

Work Order ID: 52627



Page 1

October 5, 2009 8:48:31 AM

Item ID: D412-694-03

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Door Assembly

Start Date: 10/05/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 09/16/05

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan - Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	----------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D412-694	Rev C1

100
DOCUMENT CONTROL
0.00
DC
Memo
Document Control
Issue red decal labels for D412-694-03. CHG005

11-09-27

110
COMPOSITE ASSEMBLY
0.00
Small Fab
Memo
Small Fab
D412-694-03 Drill Process 1- Drill pilot holes Ø(#30) using drill Jig D3144-T4 for the doublers. Drill (2) holes in two places Ø3/16" (0.188) for the slot opening. Router slot using D3144-T5/-T6 as per Dwg D412-694 page 3. Note: Ensure slot is aligned wi

11-06-29
Pto

120
COMPOSITE ASSEMBLY
0.00
Small Fab
Memo
Small Fab
1- Install inserts as per Dwg D412-694 page 3 & 5 (section AA-AA) and page 4 (view MM-MM). 2- Sand flush excess Hysol around the insert on both doors.

11-06-29
Pto

Neckish / cat

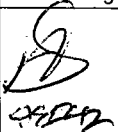
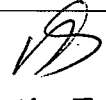
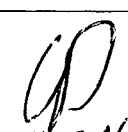
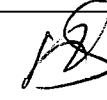
09/12/3

W/O: 52627

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-02-17	REF NC location for 3112-1 guide	laminate D3140-103 aluminum doubler @ base of door + D3140-106 aluminum doubler @ top of door using hysol 956. Fill holes in foam core using Hysol 956, 10% milled fiber and up to 20% silica. trim doublers as necessary. (let cure). Feather edges of surrounding composite material surrounding doublers.	RT	11-02-16	1	11-02-15	11-07-11
"	"	build up over doubler area to achieve original volume using 902 cloth + hysol 956. cover repaired area as per QSI 37. TRIM D3140-106 TO FIT PROFILE OF DOOR. LEAVE FOAM CORE UNFILLED D3140-103 & 34377 D3140-106 B34380 Hysol 956 110637		11-02-16	1	11-02-15 DSI 042	11-07-11

Part No: D412-694-03 PAR #: _____ Fault Category: Small M Design NCR: Yes No DQA: A Date: 11-10-07
11-8-11 Resolution: Re-work Disposition: Re-work QA: N/C Closed: CK Date: 11/10/11

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-02-10	110	location for D3112-1 guide as per Dwg 412-694 Rev C is wrong. Re: Proceed		Remove D3140-103 + D3140-106 aluminum doublers + install new ones as per QSI 37 + QSI 6	RT 11-02-16	 11-07-11	 11-02-15 DSI 042	 11-07-11

NOTE: Date & initial all entries

W/O: 52627

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.04.08	120	no more Hysol 956 avail for up to 8 weeks use Hysol 956 or 9309.3 as replacement as per QSC				11.04.08 PBL Q5103772	
11.06.23	120	^{Affected - 11.06.23} REINSTALL VINserts WITH HYSOL EA934ND PER QSI 006 4.16.4 Hysol 934 B 117700 inserts 80-005-2-8 #5 m 113109	BT	11-06-27	1	CP 11.06.23 Q51042	AB 11.07.11

Part No: D412-694-03 PAR #: N/A Fault Category: Composite NCR: Yes No DQA: A Date: 11.10.07
 NCR 11-560 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 11/10/11

WORK ORDER NON-CONFORMANCE (NCR) 10.59

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.07.11	120	D3159-043 bracket Assy moved while being transfer drilled on door hole for rivet too close to edge R.C. employee error LOA	CP 11.07.11 Q51042	Scrap D3159-043 bracket Assy B 24859 + replace w/ B 24707	CP 11.07.13	AB 11.07.13	CP 11.07.11 Q51042	AB 11.07.13

NOTE: Date & initial all entries

[illegible]

Page 2

[illegible]

Stop

Year	Age	Sex	Weight (kg)	Height (cm)	Body Mass Index (kg/m ²)	Waist Circumference (cm)	Hip Circumference (cm)	Waist-Hip Ratio	Trunk Fat (%)	Visceral Fat (cm ³)	Subcutaneous Fat (cm ³)	Visceral Fat Index (cm ³ /m ²)	Subcutaneous Fat Index (cm ³ /m ²)	Visceral Fat to Subcutaneous Fat Ratio
2000	20	M	75.0	175.0	24.5	95.0	105.0	0.90	15.0	150.0	150.0	1.00	1.00	1.00
2001	21	F	65.0	165.0	23.8	85.0	95.0	0.89	12.0	120.0	120.0	1.00	1.00	1.00
2002	22	M	80.0	180.0	24.7	100.0	110.0	0.91	18.0	180.0	180.0	1.00	1.00	1.00
2003	23	F	70.0	170.0	24.1	90.0	100.0	0.90	14.0	140.0	140.0	1.00	1.00	1.00
2004	24	M	85.0	185.0	24.8	105.0	115.0	0.91	20.0	200.0	200.0	1.00	1.00	1.00
2005	25	F	75.0	175.0	24.5	95.0	105.0	0.90	16.0	160.0	160.0	1.00	1.00	1.00
2006	26	M	90.0	190.0	25.0	110.0	120.0	0.92	22.0	220.0	220.0	1.00	1.00	1.00
2007	27	F	80.0	180.0	25.0	100.0	110.0	0.91	18.0	180.0	180.0	1.00	1.00	1.00
2008	28	M	95.0	195.0	25.1	115.0	125.0	0.92	24.0	240.0	240.0	1.00	1.00	1.00
2009	29	F	85.0	185.0	25.0	105.0	115.0	0.91	20.0	200.0	200.0	1.00	1.00	1.00
2010	30	M	100.0	200.0	25.0	120.0	130.0	0.92	26.0	260.0	260.0	1.00	1.00	1.00

Reference:

(b) (5) DPP, (b) (7)(C), (b) (7)(D)

Stop

Abstract

**Insp.
Stamp**

0.00

Inspect that inserts are flush with the surface.

0.00

0.00

Memo

1. Apply Primer filler and reducer around the inserts on both doors. □ A/R

Batch: 116563 ☐ A/R

Batch: 116563

0.00

[illegible]

Memo

0.00

Quality Control

W/O: 52627

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.09.27	160	Acceptable to use Qty (2) MS51859-7 WASHERS INSTEAD OF (3). REF SECTION B3-B3. Acceptable. USED AS SPACERS TO GET PROPER FUR HANDLE.	ET	11-09-27		<p>11.09.27</p> <p>PS/042</p>	<p>11.09.27</p>

Part No: D412-694-03 PAR #: _____ Fault Category: Small Fab NCR: Yes No DQA: 11 Date: 11.10.07
11-861 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CP Date: 11/10/11

NCR:

WORK ORDER NON-CONFORMANCE (NCR) # 10790

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.09.13	160	One hole for attaching Interior trim in wrong location RC: equip/tooling (per C.P.)	<p>11.09.13</p> <p>PS/042</p>	<p>SCRAP/REPLACE D3119-041 COVER. FILL HOLE IN DOOR W/ HYDOL. DRILL HOLE IN CORRECT LOCATION</p> <p>D3119-041 B60662 x1</p>	<p>11.09.13</p> <p>ET</p>	<p>11.09.13</p>	<p>11.09.13</p> <p>PS/042</p>	<p>11.09.13</p>

NOTE: Date & initial all entries

Work Order ID 52627

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Item ID: D412-694-03

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Door Assembly

Start Date: 10/05/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



COMPOSITE ASSEMBLY

Small Fab

Memo

0.00

Small Fab

D412-694-03 Assembly Process ☐ 1- Install top/bottom of the door, D3112-1 Guard, D3130-1 Clevis Base and D3131-1 Stop (top only) as per Dwg D412-694 page 5 (section AA-AA & FF-FF). ☐ 2- Install D3111-041 Plate Assembly. If needed, install temporary D3110-3

IT 11-06-28

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Install door on mock up helicopter to insure proper fit and function.

B 11-09-27

180

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

(Put red label inside before putting the cover D3119-041/or Vip trim) ☐ 1- Install D3119-041 Cover and Assemble Handle as per Dwg D412-694 page 3 & 5 (section BB-BB). Align properly.

ET 11-09-27

Work Order ID 52627

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Item ID: D412-694-03

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Door Assembly

Start Date: 10/05/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	8/11/09/27						
200 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00	MP 52260						sf 11/9/30sf
210 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/10/5 MP 11-10-5

Picklist Print

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Page 1

Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS43DD3-40  Spacer		Purchased	No			130	Each	15.0000	2.0000			

11-02-08

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 15
110153 10
112314 5

x2

80-005-2-8



Insert

Purchased

No

160

Each

92.0000 (21.0000)



11-02-08

11/3/09

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 92
112439 20
19443 72

ALS4-632-80



Insert

Purchased

No

160

Each

255.0000 10.0000



11-02-08

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 255
112495 200
17841 55

x8
x2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN525-10R7  Screw		Purchased	No			160	Each	147.0000	4.0000			

115016

ST 11-02-08

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	147	
106166	30	
110844	15	
112314	18	
112411	84	

AN960JD10

NA51149003635

Purchased

No

160

Each

1,958.000 8.0000



Washer

118007

ST 11-02-08

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1958	
105442	95	
109059	2	
109840	23	
110985	202	
111279	5	
111668	64	
112314	1000	
112369	567	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly

Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10L [NAS 1149 D03325]		Purchased	No			160	Each	6,143.000	13.0000			
Washer												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	6143	
101291	16	
104885	153	
105793	236	
109632	738	
110985	5000	

AN960JD10LL NAS 1149 D03165		Purchased	No			160	Each	4,062.000	29.0000			
Washer												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	4062	
19085	376	
19600	3686	

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly



Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD6L  Washer		Purchased	No			160	Each	1,405.000	4.0000			
										 2T 11-02-08		

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 1405

5519 1405

AN960JD8 ~~114511490N8325~~ Purchased No 160 Each 1,731.000 2.0000



Washer

~~116805~~ 117316



2 11-02-08

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 1731

107091 9

108335 11

110382 48

110917 3

111578 360

112314 500

112385 800

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD8L  Washer		Purchased	No			160	Each	503.0000	2.0000			


14808

IT 11-02-08

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 503
6956 503

BSP45  Commercial Rivet		Purchased	No			160	Each	391.0000	34.0000			
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1129337 x 26


IT 11-02-08

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 391
107296 191
112794 200
11821 0

(QXO) →

BSP46  Commercial rivet		Purchased	No			160	Each	406.0000	12.0000			
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IT 11-02-08

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 406
101237 106
112540 300
14230 0

X127

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Shop Packet Print

Page 5

W/O: 52627

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-09-13	160	8 of the BSP 45 rivets are too short replace w/8 BSP 46 B101237 x 8	BT	11-09-13	/	CP 11.09.13 CP 10/12	11.10.05

Part No: DH12-694-03 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3110-1RevC  Escutcheon		Manufactured	No			160	Each	2.0000	1.0000			

54-198



RT 10-02-08

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 2

31757 2

D3110-3RevC  Handle		Manufactured	No			160	Each	5.0000	1.0000			
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6066P



RT 11-02-08

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 5

50041 5

D3111-041RevB  Plate Assembly		Manufactured	No			160	Each	121.0000	1.0000			
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RT 11-02-08

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 121

1053617 121

41

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly



Comments:

Start Date: 10/05/09



Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3112-1RevB  Guide		Manufactured	No			160	Each	17.0000	2.0000 		ST 11-02-06	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	7	
23698	0	
41644	7	
Main Warehouse		
ST66	10	
50304	10	

D3113-1RevB  Spring		Manufactured	No			160	Each	17.0000	1.0000 		ST 11-02-06	
--	--	--------------	----	--	--	-----	------	---------	---	--	-------------	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	17	
367257	17	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 5, 2009 8:48:30 AM

Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly



Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3114-1RevB		Manufactured	No			160	Each	17.0000	1.0000			
												
Pivot												

BT 11-02-08



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 17

36726 17

ST

D3116-11RevA		Manufactured	No			160	Each	778.0000	1.5000			
												
Seal												

BT 11-02-08



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 778

27241 778

ST

D3116-5RevA		Manufactured	No			160	f	672.0100	5.6700			
												
Seal												

BT 11-02-08

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 672.01

23699 18

27208 654.01

ST

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 5, 2009 8:48:30 AM

Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly

Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3119-041RevB

Manufactured

No

160

Each

1.0000

1.0000



Cover Assembly

52627



85 11-02-08

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

27724

1

D3120-1RevB

Manufactured

No

160

Each

8.0000

1.0000



Cover



85 11-02-08

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8

1053617

2

50531

6

D3120-3RevB

Manufactured

No

160

Each

2.0000

2.0000



Cover



66219

85 11-02-08

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

1053717

1

50315

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly

Comments:

Start Date: 10/05/09


Required Date: 11/13/09


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3125-1RevC		Manufactured	No			160	Each	54.0000	1.0000			
<div style="display: flex; justify-content: space-between;"> <div>  <p>Lever</p> </div> <div> <p><u>Warehouse</u></p> <p><u>Location</u></p> <p>Main Warehouse</p> <p>ST</p> <p>1053617</p> </div> <div> <p><u>Loc Qty</u></p> <p>54</p> <p>54</p> </div> <div> <p><u>Loc Code</u></p> <p></p> </div> <div> <p><u>Qty To Pick</u></p> <p>1.0000</p> </div> <div> <p><u>Date Issued</u></p> <p>11-02-08</p> </div> </div>												

D3125-3RevC		Manufactured	No			160	Each	105.0000	1.0000			
<div style="display: flex; justify-content: space-between;"> <div>  <p>Lever</p> </div> <div> <p><u>Warehouse</u></p> <p><u>Location</u></p> <p>Main Warehouse</p> <p>ST</p> <p>1053617</p> </div> <div> <p><u>Loc Qty</u></p> <p>105</p> <p>105</p> </div> <div> <p><u>Loc Code</u></p> <p></p> </div> <div> <p><u>Qty To Pick</u></p> <p>1.0000</p> </div> <div> <p><u>Date Issued</u></p> <p>11-02-08</p> </div> </div>												

D3125-5RevC		Manufactured	No			160	Each	119.0000	1.0000			
<div style="display: flex; justify-content: space-between;"> <div>  <p>Lever</p> </div> <div> <p><u>Warehouse</u></p> <p><u>Location</u></p> <p>Premier</p> <p>Mezz</p> <p>1053617</p> </div> <div> <p><u>Loc Qty</u></p> <p>119</p> <p>119</p> </div> <div> <p><u>Loc Code</u></p> <p></p> </div> <div> <p><u>Qty To Pick</u></p> <p>1.0000</p> </div> <div> <p><u>Date Issued</u></p> <p>11-02-08</p> </div> </div>												

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52627



Parent Item: D412-694-03RevC1



Parent Item Name: Door Assembly

Start Date: 10/05/09

Required Date: 11/13/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3125-7RevC 		Manufactured	No			160	Each	98.0000	1.0000			
Lever												

ST 11-02-09

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

98

1053617

98

D3129-1RevB



Manufactured No

160

Each

255.0000

2.0000

Lever

ST 11-02-09

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

255

1053617

255

D3130-1RevB



Manufactured No

160

Each

309.0000

2.0000

Clevis Base

ST 11-02-09

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

309

1053617

309

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3131-1RevB 		Manufactured	No			160	Each	98.0000	1.0000			
Stop												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 98

1053617 98

D3134-1RevE 		Manufactured	No			160	Each	14.0000	1.0000			
Rod												

Warehouse Loc Qty Loc Code
Location


Main Warehouse


ST 14

27338 2

50280 4

52369 8

D3134-3RevE 		Manufactured	No			160	Each	0.0000	1.0000			
Rod												

D3140-07RevF 		Manufactured	No			160	Each	0.0000	1.0000			
Door												

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 5, 2009 8:48:30 AM

Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3143-1RevB		Manufactured	No			160	Each	21.0000	1.0000			
<div>  <div> <div>60574</div> <div>IT 11-02-08</div> </div> </div>												
Clevis												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 21

1053617 21


D3143-3RevB		Manufactured	No			160	Each	175.0000	3.0000			
<div>  <div> <div>IT 11-02-08</div> </div> </div>												
Clevis												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 175

1053617 175

D3144-105RevC		Manufactured	No			160	Each	2.0000	1.0000			
<div>  <div> <div>53163</div> <div>IT 11-02-08</div> </div> </div>												
Doubler												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 2

23143 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3144-107RevC  Doubler		Manufactured	No			160	Each	6.0000	1.0000			

352616



ST 11-02-08

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
23144	2	
50396	4	

D3144-1RevC

Manufactured No

160

Each

3.0000

1.0000



Doubler



ST 11-02-08

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3	
1053617	1	
18816	2	

x()

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly



Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3145-1RevB		Manufactured	No			160	Each	9.0000	1.0000			
											ET 11-02-06	
Bracket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 4

21383 0

31733 4

Main Warehouse

ST067 5

50099 5

D3146-1RevB

Manufactured

No

160

Each

5.0000

1.0000



Bracket

157569



ET 11-02-06

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST 5

20737 0

46927 5

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 16

Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly


Comments:


Start Date: 10/05/09


Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3147-1RevC  Pin		Manufactured	No			160	Each	21.0000	2.0000			
<div> <div>062693-76</div> <div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>41616</div> <div>41930</div> </div> <div>Loc Qty</div> <div>21</div> <div>1</div> <div>20</div> </div> <div> <div>Loc Code</div> <div></div> </div>												

D3149-1RevB  Striker Plate		Manufactured	No			160	Each	107.0000	2.0000			
<div> <div></div> <div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>1053617</div> </div> <div>Loc Qty</div> <div>107</div> <div>107</div> </div> <div> <div>Loc Code</div> <div></div> </div>												

D3150-1RevB  Guide		Manufactured	No			160	Each	21.0000	2.0000			
<div> <div></div> <div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>1053617</div> </div> <div>Loc Qty</div> <div>21</div> <div>21</div> </div> <div> <div>Loc Code</div> <div></div> </div>												

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly




Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3154-1RevB  Key		Manufactured	No			160	Each	43.0000	1.0000			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>1053617</div> </div> <div> <div>Loc Qty</div> <div>43</div> <div>43</div> </div> <div> <div>Loc Code</div> <div></div> </div>												
D3157-1RevB  Spacer		Manufactured	No			160	Each	307.0000	2.0000			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>1053617</div> </div> <div> <div>Loc Qty</div> <div>307</div> <div>307</div> </div> <div> <div>Loc Code</div> <div></div> </div>												
D3159-041RevC  Bracket Assembly		Manufactured	No			160	Each	48.0000	3.0000			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>18641</div> <div>50391</div> </div> <div> <div>Loc Qty</div> <div>48</div> <div>4</div> <div>44</div> </div> <div> <div>Loc Code</div> <div></div> </div>												

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 5, 2009 8:48:31 AM

Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3159-043RevC		Manufactured	No			160	Each	20.0000	1.0000			
												
Bracket Assembly												

ET 11-02-08

Warehouse
Location

Main Warehouse

ST

20

1053617

2

24707

1

24859

17

X 1

FW10-032

Purchased

No



Washer

160

Each

372.0000

16.0000

ET 11-02-08

Warehouse
Location

Main Warehouse

ST

372

101203

210

19249

162

X 16

FW4-032

Purchased

No



Washer

160

Each

120.0000

6.0000

ET 11-02-08

Warehouse
Location

Main Warehouse

ST

120

101203

94

11822

26

X 6

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Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 5, 2009 8:48:31 AM

Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly

Comments:



Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00



Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M7885/3-4-4		Purchased	No			160	Each	264.0000	2.0000			
												
Rivets												

RT 11-02-06

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	264	
104625	86	
108077	178	



182

M7885/3-4-5		Purchased	No			160	Each	80.0000	1.0000			
												
Rivet												

RT 11-02-08

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	80	
1108	80	

182

MS20392-1C11		Purchased	No			160	Each	75.0000	2.0000			
												
Pin												

RT 11-02-08

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	75	
18822	75	

182

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20392-2C11		Purchased	No			160	Each	66.0000	2.0000			
												
Pin												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 66

14149 66

MS20392-2C15		Purchased	No			160	Each	58.0000	7.0000			
												
Pin												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 58

101334 15

101340 43

October 5, 2009 8:48:31 AM

Shop Packet Print

Page 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 5, 2009 8:48:31 AM

Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly



Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L06  Nut		Purchased	No			160	Each	425.0000	2.0000			
C116549  RT 11-02-08												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	425	
110123	11	
110731	14	
111548	1	
112243	99	
112369	100	
112433	100	
112465	100	

MS21042L3

Purchased

No

160

Each

3,579.000 7.0000



Nut

115835



RT 11-02-08

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	3579	
110844	32	
111274	55	
111668	992	
112314	2000	
112385	500	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 5, 2009 8:48:31 AM

Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS24665-151  Cotter Pin		Purchased	No			160	Each	943.0000	11.0000			

RT 11-02-08

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

943

14526

64

17566

879

MS24694-C4



SCREW

Purchased

No

160

Each

268.0000

2.0000

LT 12

RT 11-02-08

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

268

15924

268

MS24694-S53



SCREW

Purchased

No

160

Each

11.0000

2.0000

RT

RT 11-02-08

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

11

15798

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 5, 2009 8:48:31 AM

Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS24694-S56  SCREW		Purchased	No			160	Each	154.0000	4.0000			

ST 11-02-08

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

154

104407

154

CX4

MS24694-S60

Purchased

No

160

Each

229.0000

4.0000

Screw

ST 11-02-08

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

229

104407

227

11766

2

ST CX4

MS25281-R6

Purchased

No

160

Each

92.0000

2.0000

Clamp

ST 11-02-08

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

92

19098

92

CX2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 5, 2009 8:48:31 AM

Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly

Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS27039-1-06

Purchased

No

160

Each

1,006.000

12.0000



Screw

RT 11-02-08

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1006

104289

986

106815

20

812

MS27039-1-08

Purchased

No

160

Each

3,088.000

6.0000



Screw

115108

RT 11-02-08

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3088

110467

192

110552

896

110835

2000

MS35206-231

Purchased

No

160

Each

50.0000

2.0000



Screw

RT 11-02-08

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

50

11735

50

827

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 5, 2009 8:48:31 AM

Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS35650-305T  Nut		Purchased	No			160	Each	116.0000	4.0000			


ST 11-02-08

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 116
11786 116

X4

MS51859-7  Washer		Purchased	No			160	Each	62.0000	3.0000			
---	--	-----------	----	--	--	-----	------	---------	--------	--	--	--


ST 11-02-08

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 62
11193 62

X3

NAS1169-10L  Washer		Purchased	No			160	Each	30.0000	4.0000			
---	--	-----------	----	--	--	-----	------	---------	--------	--	--	--

ST 11-02-08

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 30
11753 30

X4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 5, 2009 8:48:31 AM

Work Order ID: 52627

Parent Item: D412-694-03RevC1

Parent Item Name: Door Assembly



Comments:

Start Date: 10/05/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS388-6-8P		Purchased	No			160	Each	69.0000	15.0000			
						113470				RT	11-02-08	
Screw												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 69

111439 13

112768 56

NAS391B6P

Purchased

No

160

Each

183.0000

16.0000



Washer

115589



RT 11-02-08

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 183

110221 12

112195 71

112616 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

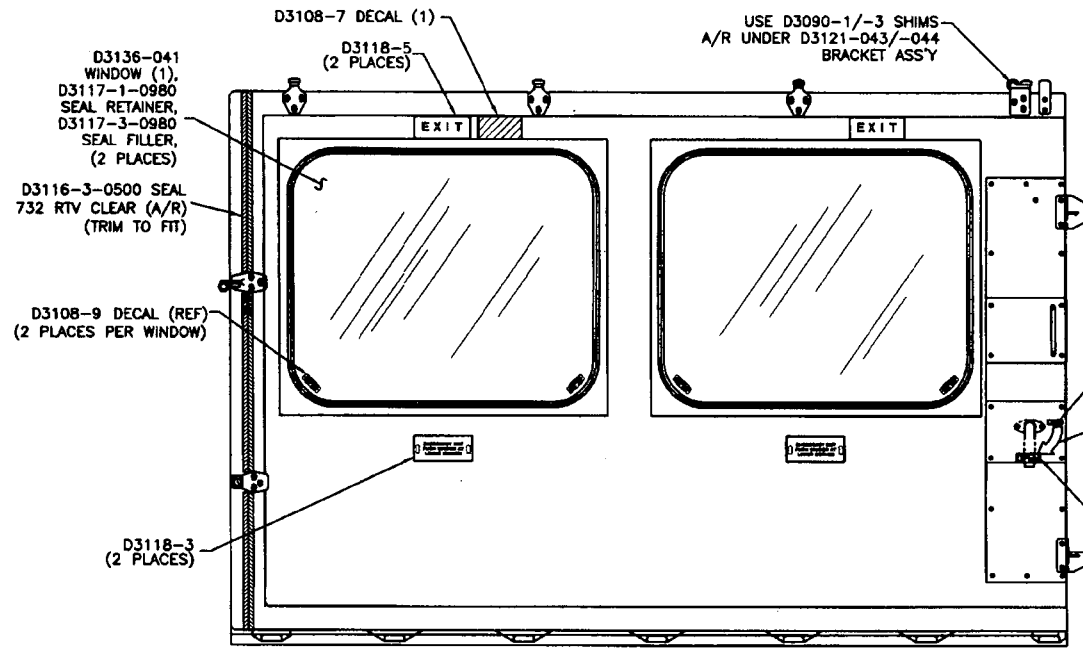
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

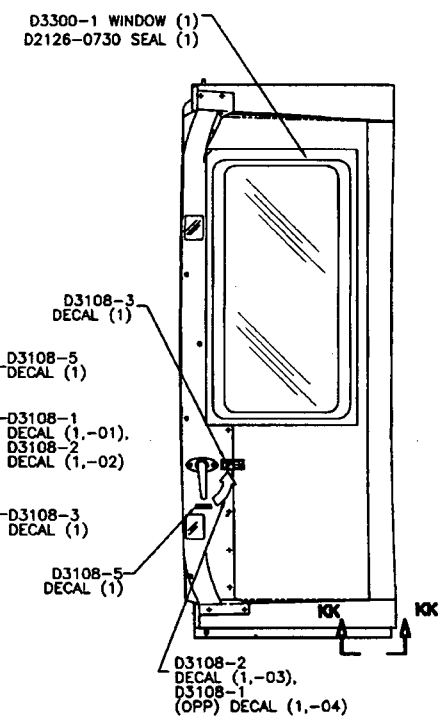
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FIGURE 2: Decal Installation

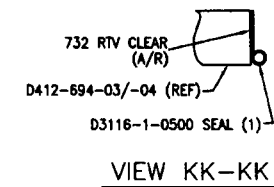


D412-694-01 DOOR ASSY (SHOWN)
D412-694-02 DOOR ASSY (OPP.)
VIEW LOOKING ● INSIDE OF DOOR



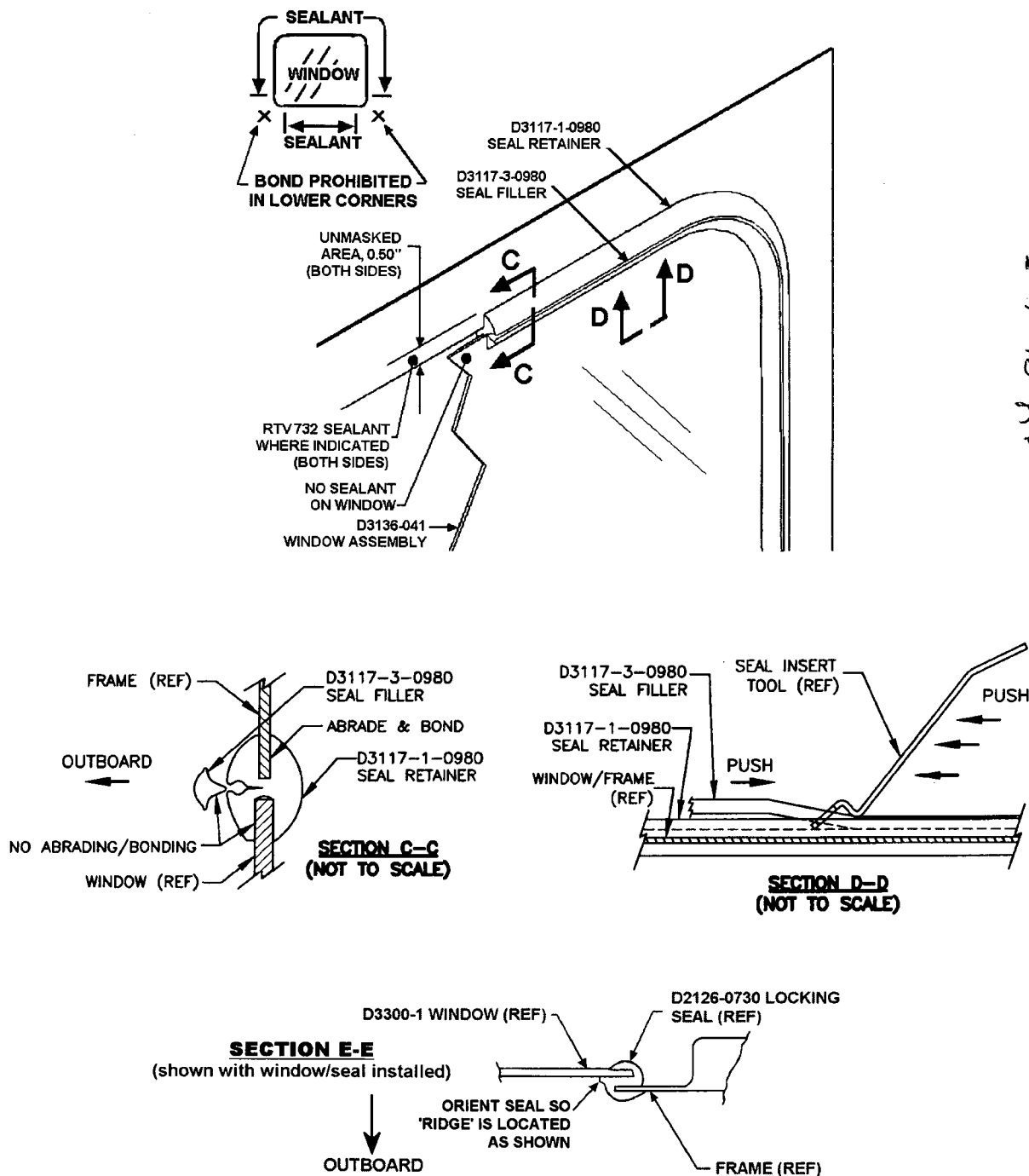
D412-694-03 DOOR ASSY (SHOWN)
D412-694-04 DOOR ASSY (OPP)
VIEW LOOKING ● INSIDE OF DOOR

NOTE: THE PARTS LABELLED IN THIS DIAGRAM ARE INSTALLED BY THE CUSTOMER AFTER PAINT.
ALL OTHER PARTS COME PRE-ASSEMBLED ON THE DOOR.



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52627

Revision: **B**
Date: 04.10.07



0209110105
W10.52627

FIGURE 3: window/Seal Installation, (D412-694-01/02 Door Assembly)

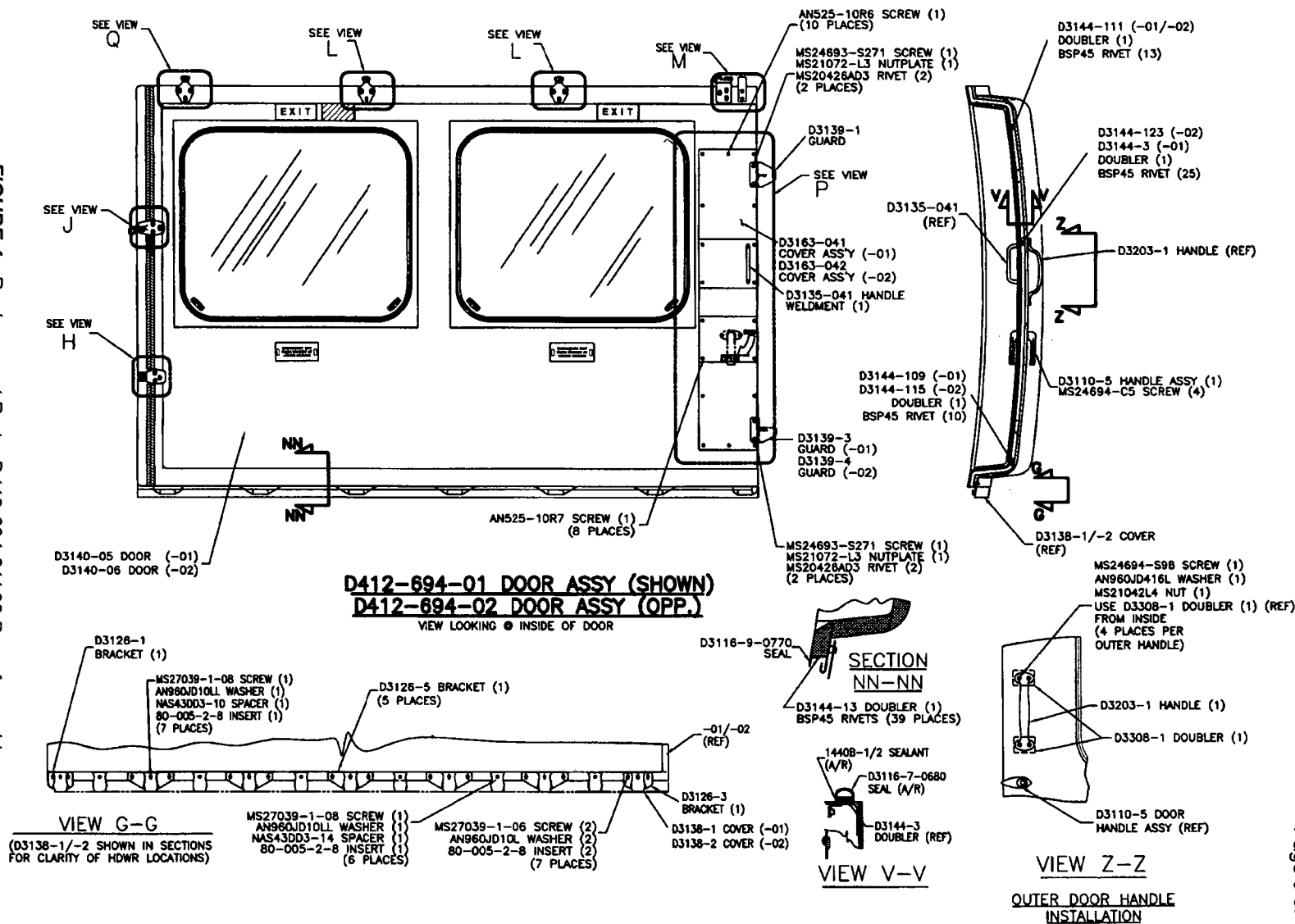
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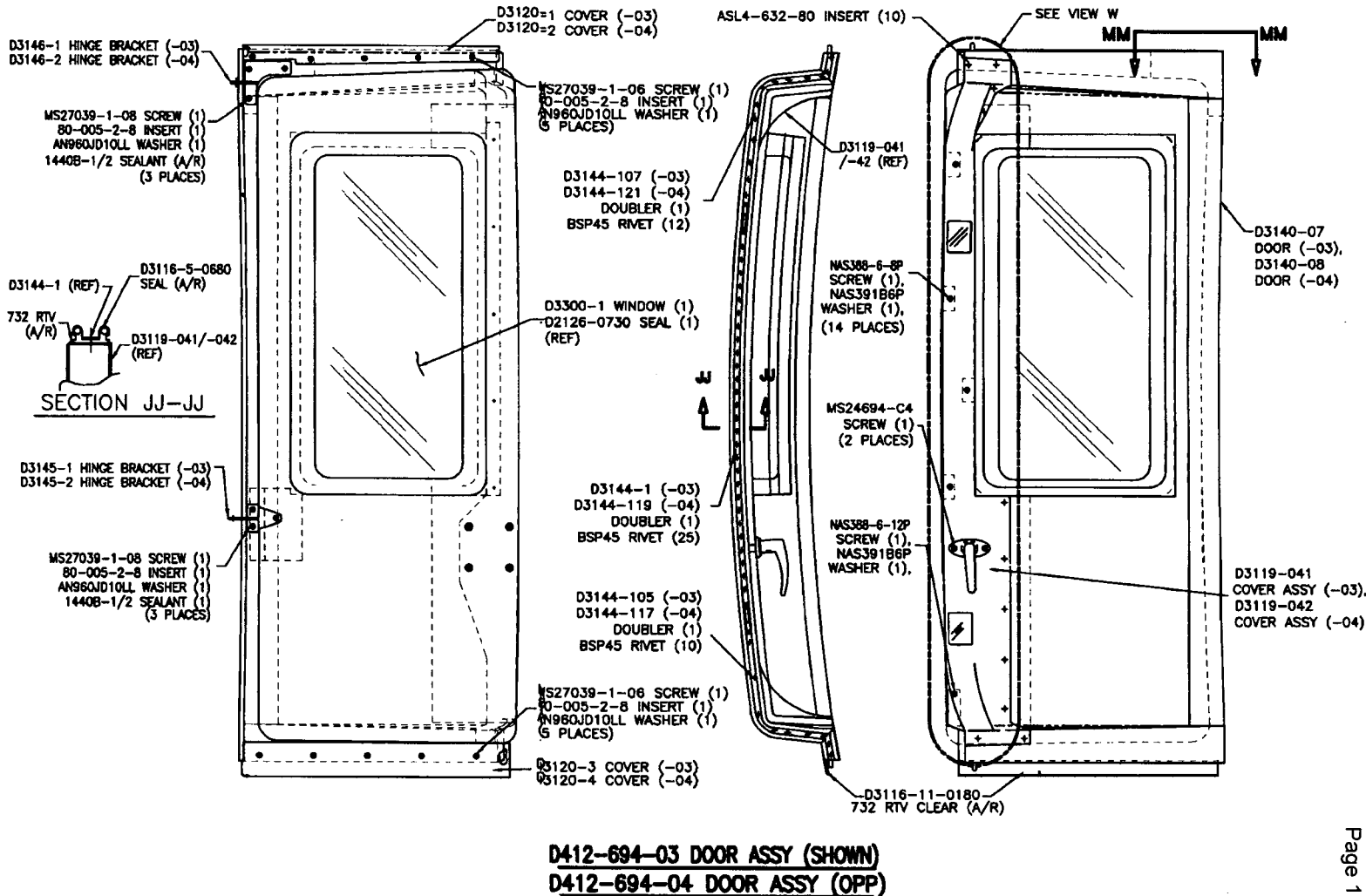
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FIGURE 4: Replacement Parts, D412-694-01/-02 Door Assembly



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c209110105
w/0: 52627



0209110/09
W10' 52627

FIGURE 5: Replacement Parts, D412-694-03/-04 Door Assembly

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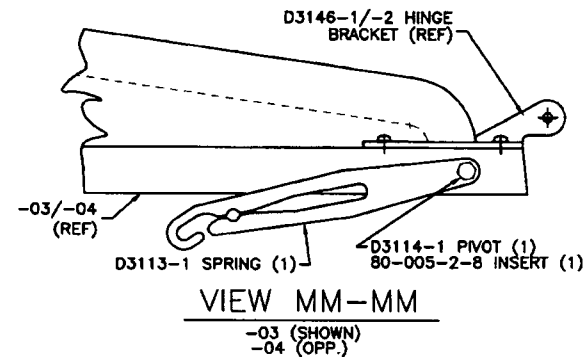
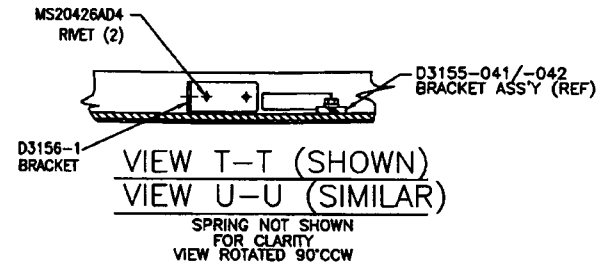
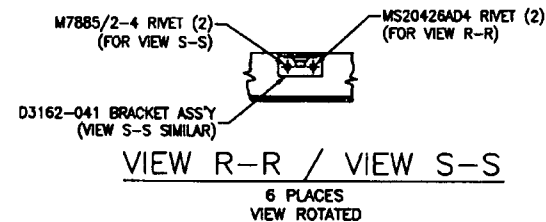
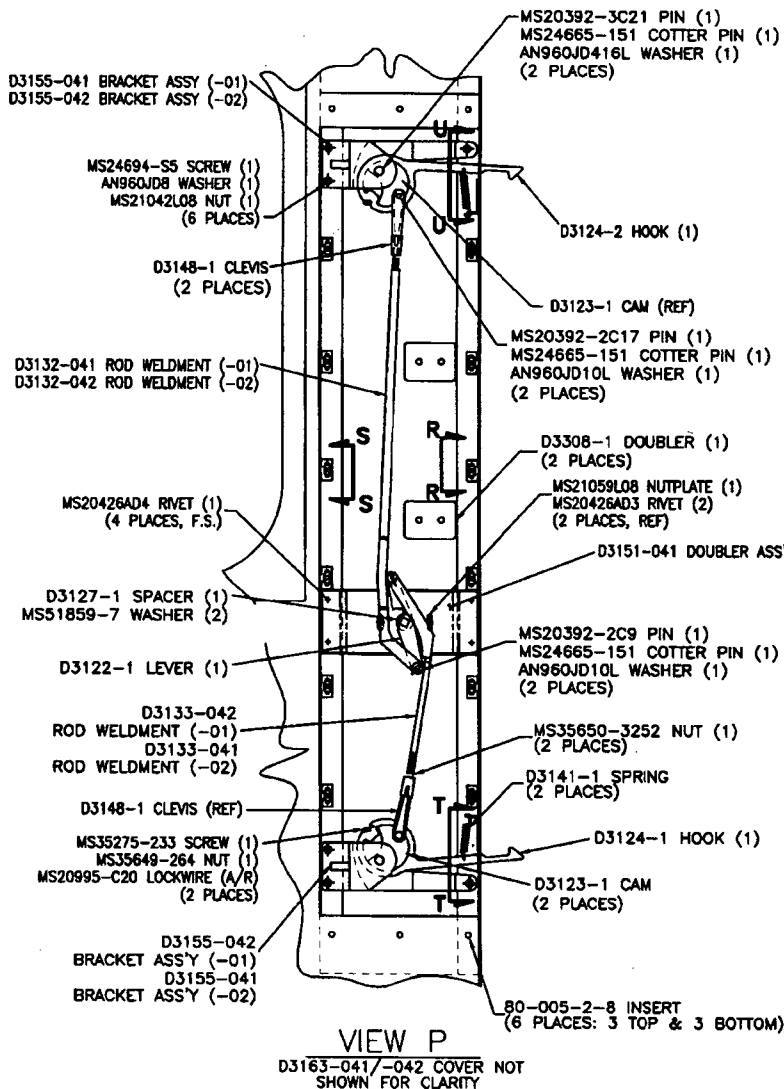
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Date: 04.10.07

FIGURE 6: Replacement Parts, Door Assembly Details

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Revision: B
Date: 04.10.07

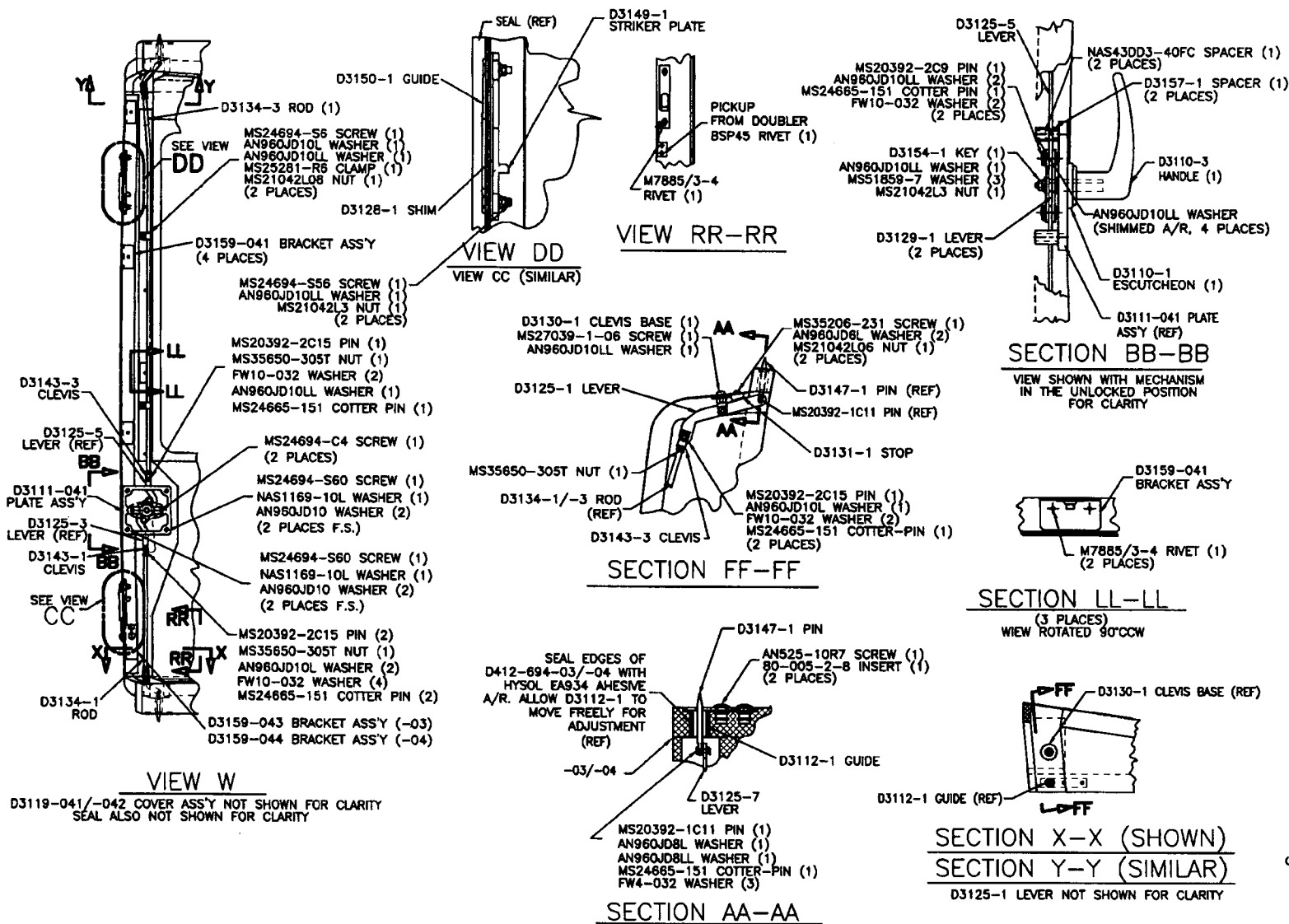


C209110105
W10: 52627

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FIGURE 7: Replacement Parts, Door Assembly Details



C 209110105
W10: 52627

Revision: B
Date: 04.10.07

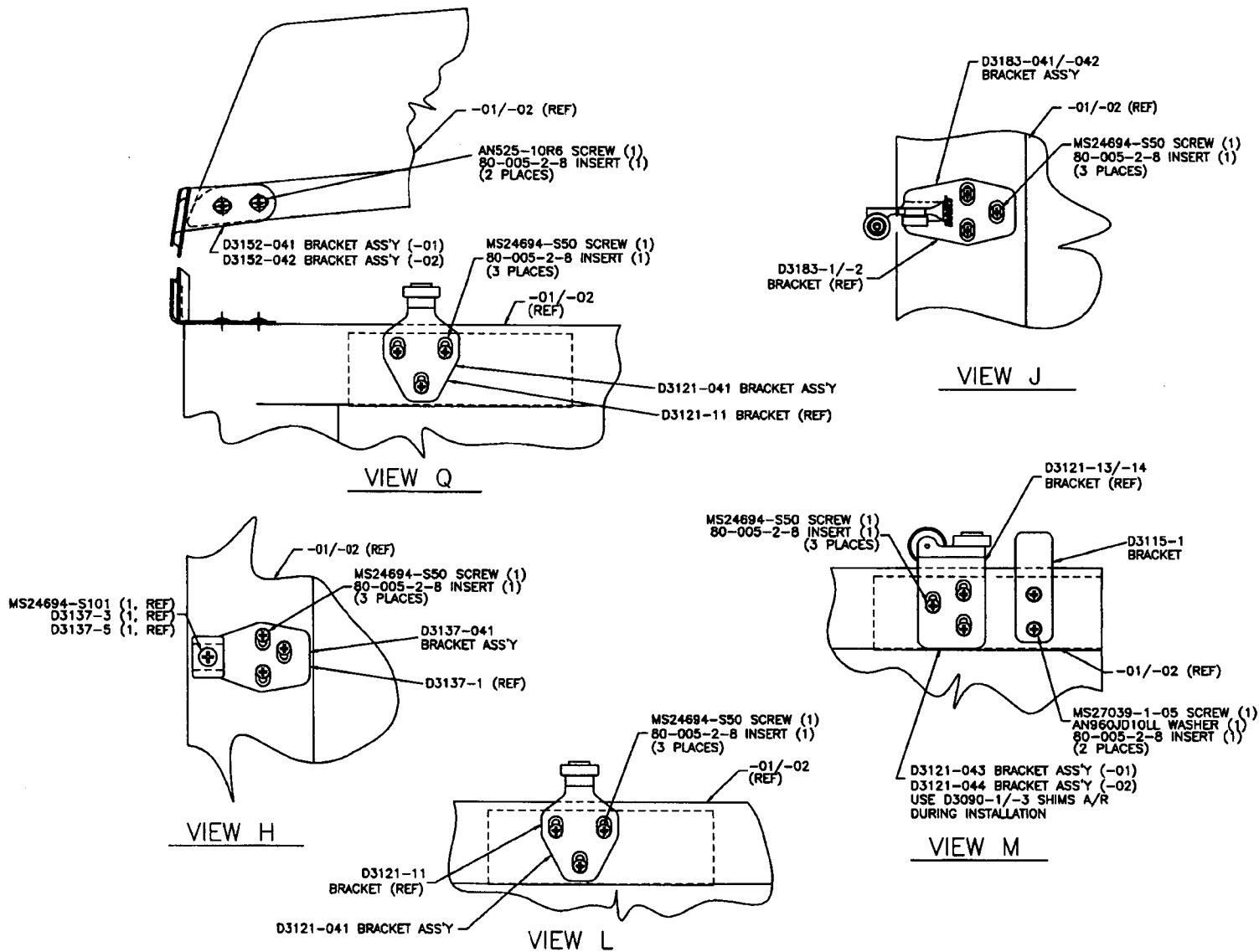
FIGURE 8: Replacement Parts, Door Assembly Details

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Revision: B

Date: 04.10.07



C209110105
W10: 52627

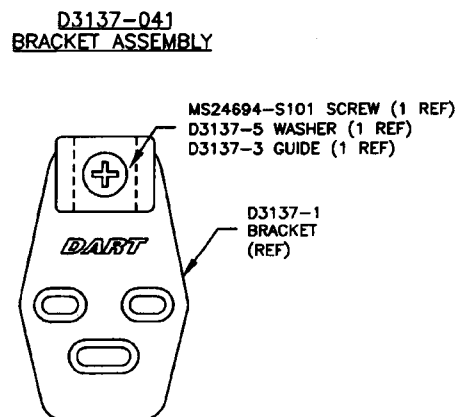
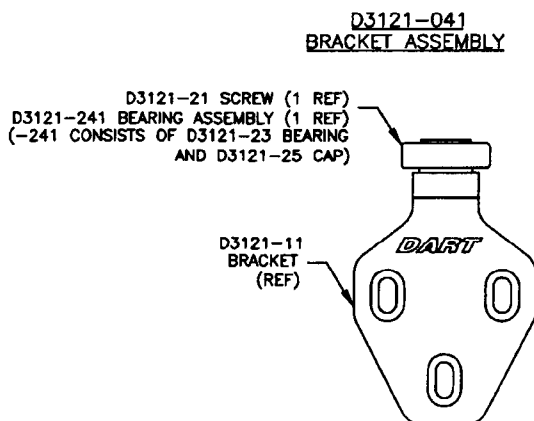
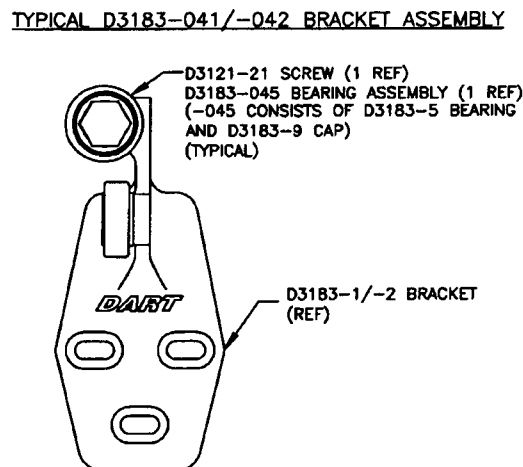
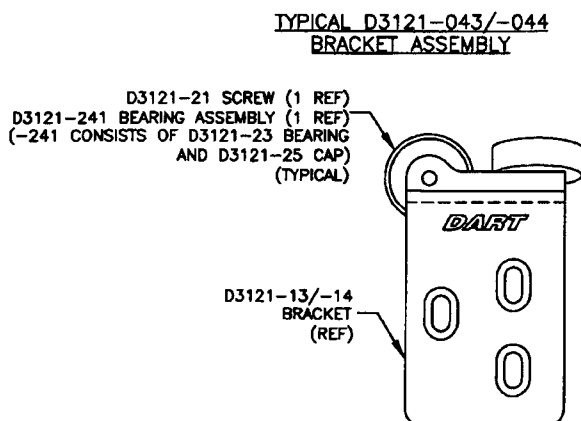


FIGURE 9: Replacement Parts, D412-694-01/-02 Door Assembly

c209110/05
W/D: 52627

6. PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X								D412-694-011	SPACEDOOR™ INSTALLATION
	X							D412-694-013	PANEL INSTALLATION (OPTIONAL)
4		X						D412-694-015	REPLACEMENT WINDOW KIT
			X					D412-694-017	BEARING OVERHAUL KIT
1				X				D412-694-01	DOOR ASSEMBLY
1					X			D412-694-02	DOOR ASSEMBLY
1						X		D412-694-03	DOOR ASSEMBLY
1							X	D412-694-04	DOOR ASSEMBLY
2								D2126-0730	SEAL
4								D3090-1	SHIM
4								D3090-3	SHIM
2								D3108-1	DECAL
2								D3108-2	DECAL
4								D3108-3	DECAL
4								D3108-5	DECAL
2								D3108-7	DECAL
						1	1	D3110-1	ESCUTCHEON
						1	1	D3110-3	HANDLE
				1	1			D3110-5	HANDLE ASSEMBLY
						1	1	D3111-041	PLATE ASSEMBLY
						2	2	D3112-1	GUIDE
						1	1	D3113-1	SPRING
						1	1	D3114-1	PIVOT
				1	1			D3115-1	BRACKET
2								D3116-1-0500	SEAL
						1	1	D3116-11-0180	SEAL
2								D3116-3-0500	SEAL
						1	1	D3116-5-0680	SEAL
				1	1			D3116-7-0680	SEAL
				1	1			D3116-9-0770	SEAL
		1						D3117-1-0980	SEAL RETAINER
		1						D3117-3-0980	SEAL FILLER
4								D3118-3	SIGN ASSEMBLY
4								D3118-5	SIGN ASSEMBLY
						1		D3119-041	COVER ASSEMBLY
							1	D3119-042	COVER ASSEMBLY
						1		D3120-1	COVER
							1	D3120-2	COVER
						1		D3120-3	COVER
							1	D3120-4	COVER
				3	3			D3121-041	BRACKET ASSEMBLY ("ROLLER")
				1				D3121-043	BRACKET ASSEMBLY ("ROLLER")
					1			D3121-044	BRACKET ASSEMBLY ("ROLLER")
			7					D3121-21	SCREW

C209110/05
W/O: 52627

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Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
			5					D3121-241	BEARING ASSEMBLY
				1	1			D3122-1	LEVER
				2	2			D3123-1	CAM
				1	1			D3124-1	HOOK
				1	1			D3124-2	HOOK
						1	1	D3125-1	LEVER
						1	1	D3125-3	LEVER
						1	1	D3125-5	LEVER
						1	1	D3125-7	LEVER
				1	1			D3126-1	BRACKET ("SLIDER")
				1	1			D3126-3	BRACKET ("SLIDER")
				5	5			D3126-5	BRACKET ("SLIDER")
				1	1			D3127-1	SPACER
						1	1	D3128-1	SHIM
						2	2	D3129-1	LEVER
						2	2	D3130-1	CLEVIS BASE
						1	1	D3131-1	STOP
				1				D3132-041	ROD WELDMENT
					1			D3132-042	ROD WELDMENT
					1			D3133-041	ROD WELDMENT
				1				D3133-042	ROD WELDMENT
						1	1	D3134-1	ROD
						1	1	D3134-3	ROD
				1	1			D3135-041	HANDLE WELDMENT
		1						D3136-041	WINDOW ASSEMBLY
				2				D3137-041	BRACKET ASSEMBLY ("ROLLER")
			1					D3137-3	GUIDE
			1					D3137-5	WASHER
				1				D3138-1	COVER
					1			D3138-2	COVER
				1	1			D3139-1	GUARD
				1				D3139-3	GUARD
					1			D3139-4	GUARD
				1				D3140-05	DOOR
					1			D3140-06	DOOR
						1		D3140-07	DOOR
							1	D3140-08	DOOR
				2	2			D3141-1	SPRING
						1	1	D3143-1	CLEVIS
						3	3	D3143-3	CLEVIS
						1		D3144-1	DOUBLER
						1		D3144-105	DOUBLER
						1		D3144-107	DOUBLER
				1				D3144-109	DOUBLER
				1	1			D3144-111	DOUBLER
					1			D3144-115	DOUBLER
							1	D3144-117	DOUBLER
							1	D3144-119	DOUBLER

C209/10/05
W/O: 52627



DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	13251
Customer #	DART

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada


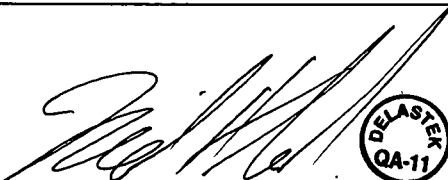
Telephone: 613-632-5200
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
26/11/2009	22/09/2009	6041	Chantal Lavoie		PO10435		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC135-0017	LINE #3 D3140-05 Door Left Non Assy (Grosse) DWG D3140 REV. F Job: 22383			
1	0	1	DKC135-0018	LINE #4 D3140-07 Door Left Non Assy (Petite) DWG D3140 REV. F Job: 22383			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:



Quality department AQ-357

Date: Mardi, 2009-10-06 14:53:23
Utilisateur: marc dubé

Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: DOOR KIT	6
Numéro Job	: 22383	Numéro Article	: DKC135-0017/-0018	
Numéro Soumission	: 3406	Numéro Dessin	: D3140	
Numéro B.A.	:	Projet Numéro	: DK-359	
Cette fois	: 2009-10-06	Révision dessin	: F	
Prsht Rev.	: NC	Matériel	: Fibercote E-761	
Prem. fois	: - -	Date Dûe	: 2009-10-13	Qté: 1 UdM: UNITE
Job précédente	:			
Écrit par	:			
Vérifié & Approuvé par	:			
Commentaires	: N° de pièce Client: D3140-05/-07			

Process Sheet Rév.: 01 Remplacer le Doubler Kit N° AAC1612 par des N° de détails AAC1630, AAC1631, AAC1632, AAC1634, AAC1635, AAC1637, AAC1638, AAC1639, AAC1641, AAC1643 & AAC1644

Produit additionnel

Numéro Job:



Séq.:

Machine ou Opération:

Description:

1.0

OUTILLAGE

Outils nécessaires pour la job



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Moule N° B30-23000-01T

Patron de découpe N° B30-23000-57T

Patron de découpe N° B30-23000-61T

Patron de découpe N° B30-23000-63T

Patron de découpe N° B30-23000-71T

Patron de découpe N° B30-23000-73T

Patron de découpe N° B30-23000-75T

Patron de découpe N° B30-23000-77T

Patron de découpe N° B30-23000-79T

Gabarit de taillage N° B30-23000-05T (2 pièce) et N° B30-2300-03T

Forme de silicone N° B30-23000-07T

2.0

AAC0854

Frekote #700-NC

Commentaire Qty.: 0.030 UNITE(s)/Unit Total: 0.030 UNITE(s)

Frekote #700-NC

N° de Lot:

1-6557-1

3.0

PRÉPARATION

Préparation du moule



Commentaire Setup: 0.00Hrs/ Run: 130.0000Min Total Run : 2.1667Hrs

Faire la préparation du moule selon IF135-0001 et IG 0009

Date: Mardi, 09-10-06 14:53:23
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 22383

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0017/-0018

Numéro Job:



Séq.: Machine ou Opération: Description :

4.0 AMB0211 Epoxy prepreg E-761 style 7781

Commentair Qty.: 12.30 VERGE(s)/Unit Total : 12.30 VERGE(s)
Epoxy prepreg E-761 style 7781 N° de Lot: 1-24937-1

5.0 DECOUPE Découpe manuelle des pièces



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Découpe des tissus pré-impregné E-761 en paquet de 10.5 pi*. (7 Paquet = 24.5 verges)

Quantité: 1 Date: 9-10-09 Sceau:

6.0 DRAPAGE Drapage



Commentair Setup: 0.00Hrs/ Run: 12.0000Hrs Total Run : 12.0000Hrs

Faire le drapage de 3 plis de tissus E-761 (4 Paquets) selon IF135-0001

Quantité: 1 Date: 9-10-09 Sceau:

7.0 AC0883 Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)

8.0 AC0884 Wrightlon 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)

9.0 AC0885 Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

10.0 AC0882 Sac à vide N° Stretchlon 700

Commentair Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)

11.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)

12.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le bagging sur la pièce selon IF135-0001 et IG 0012

Quantité: 1 Date: 9-10-09 Sceau:

13.0 CUISSON Cuisson de pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièce selon IF135-0001, IG 0012 et PTN #20 N° de Cuisson: 6121

Date: Mardi, 2009-10-06 14:53:23
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 22383

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0017/0018

Numéro Job:



Séq.: Machine ou Opération: Description :

Quantité: 1 Date: 09-10-09 Sceau: N.T

14.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs

Retirer le montage cuisson et faire les retouches de la pièces afin d'enlever les surplus de résines et les résidus de tissu à délaminer.

Quantité: 1 Date: 13-10-09 Sceau:

15.0

INSPECTION

Inspection générale



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Inspection de la première coquille par le département de la qualité pour s'assurer qu'il n'y aie pas de réparation à faire avant la prochaine étape.

Quantité: 1 Date: 13-01-09 Sceau:

16.0

AAC1618

Rohacell 71S 1"thick 49.2" x 98.4" plain

Commentair Qty.: 2.00 FEUILLE(s)/Unit Total : 2.00 FEUILLE(s)

Rohacell 71S 1"thick 49.2" x 98.4" plain

N° de Lot: 1-24967-1 et 1-25513-1

17.0

DECOUPE

Découpe manuelle des pièces



Commentair Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs

Faire la découpe des pièce de mousse structurales (Rohacell) sur la scie à ruban selon IF135-0001.

Quantité: 1 Date: 3/11/09 Sceau:

18.0

SÉCHAGE/ ANEAL

Séchage / Anealing



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le séchage du Rohacell selon IF135-0001 et les information du manufacturier. N° de

Cuisson: 6733

Quantité: 1 Date: 26/10/09 Sceau:

Date: Mardi, 2009-10-06 14:53:24
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 22383

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0017/-0018

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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19.0	AAC0560	PF-7035C supp.. film epoxy adhesive
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Commentair Qty.: 55.00 PIED CARRE(s)/Unit Total : 55.00 PIED CARRE(s)
PF-7035C supp.. film epoxy adhesive N° de Lot: 1-6534-1

20.0	AAC0559	Core splice adhesive MA560.048
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Commentair Qty.: 5.00 PIED CARRE(s)/Unit Total : 5.00 PIED CARRE(s)
Core splice adhesive MA560.048 N° de Lot: 1-7154-1

21.0	AAC0563	Epoxy Epocast 87269-A/B (4*2.9)
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Commentair Qty.: 1 KIT(s)/Unit Total : 1 KIT(s)
~~Epoxy Epocast 87269-A/B (4*2.9)~~ N° de Lot: 1-24938-1
AAC1361 AD TECH P-17

22.0	AAC1630	N° D3140-09, Doubler
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-09, Doubler N° de Lot: 1-25602-1

23.0	AAC1631	N° D3140-87, Doubler
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-87, Doubler N° de Lot: 1-25602-5

24.0	AAC1632	N° D3140-91, Doubler
------	---------	----------------------

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-91, Doubler N° de Lot: 1-25602-6

25.0	AAC1634	N° D3140-95, Doubler
------	---------	----------------------

Commentair Qty.: 3 UNITE(s)/Unit Total : 3 UNITE(s)
N° D3140-95, Doubler N° de Lot: 1-25602-7

26.0	AAC1635	N° D3140-97, Doubler
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-97, Doubler N° de Lot: 1-25602-8

27.0	AAC1637	N° D3140-99, Doubler
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-99, Doubler N° de Lot: 1-25602-9

28.0	AAC1638	N° D3140-101, Doubler
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Commentair Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s)
N° D3140-101, Doubler N° de Lot: 1-25602-2

29.0	AAC1639 AAC1640	N° D3140-103, Doubler
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-103, Doubler N° de Lot: 1-25506-9

30.0	AAC1641 AAC1642	N° D3140-105, Doubler
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-105, Doubler N° de Lot: 1-25506-10

31.0	AAC1643	N° D3140-241, Doubler
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-241, Doubler N° de Lot: 1-25602-3

Date: Mardi, 2009-10-06 14:53:24

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 22383

Numéro Article: DKC135-0017/-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

32.0

AAC1644

N° D3140-301, Doubler

Commentair Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s)

N° D3140-301, Doubler

N° de Lot:

1-25602-4

33.0

NETTOYAGE

Nettoyage des pièces



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le nettoyage des doubliers selon IG 0063

Quantité: 1

Date:

3/11/09

Sceau:



34.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 960.0Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Mise en place des doubliers et des pièces de mousse structurales selon IF135-0001

Quantité: 1

Date:

4/11/09

Sceau:



35.0

AC0883

Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)

36.0

AC0884

Wrightion 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)

37.0

AC0885

Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

38.0

AC0882

Sac à vide N° Stretchlon 700

Commentair Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)

39.0

AC0886

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)

40.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le montage cuisson selon IF135-0001 et IG 0012

Quantité: 1

Date:

4/11/09

Sceau:



41.0

CUISSON

Cuisson de pièce



















Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièces selon IF135-0001, IG 0012, et PTN #20 N° de Cuisson: 6139

Date: Mardi, 2009-10-06 14:53:24
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: DOOR KIT	
Numéro Job: 22383		Numéro Article: DKC135-0017/-0018	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
	Quantité: <u>1</u> Date: <u>05 nov-09</u> Sceau: 		
42.0	DÉMOULAGE	Démoulage de la pièce	
			
Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs			
Retirer le montage cuisson de sur la pièce et enlever les résidu de ruban adhésif en teflon et les barre d'aluminium, garder seulement la barre qui sépare les deux pièces.			
	Quantité: <u>1</u> Date: <u>05 nov-09</u> Sceau: 		
43.0	DECOUPE	Découpe manuelle des pièces	
			
Commentair Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs			
Usinage des mousse structurales selon IF135-0001 et installer les doublers			
	Quantité: <u>1</u> Date: <u>11/11/09</u> Sceau: <u>B.C.</u>		
44.0	INSPECTION	Inspection générale	
			
Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs			
Faire la vérification de l'usinage intérieur pour s'assurer que tout soit conforme au dessin avant la prochaine étapes.			
	Quantité: <u>1</u> Date: <u>11/11/09</u> Sceau: 		
45.0	AMB0211	Epoxy prepreg E-761 style 7781	
Commentair Qty.: 12.30 VERGE(s)/Unit Total : 12.30 VERGE(s) Epoxy prepreg E-761 style 7781 N° de Lot: <u>1-25408-1</u>			
46.0	DRAPAGE	Drapage	
			
Commentair Setup: 0.00Hrs/ Run: 12.0000Hrs Total Run : 12.0000Hrs			
Drapage de la coquille intérieur selon IF135-0001			
	Quantité: <u>1</u> Date: <u>12 nov-09</u> Sceau: 		
47.0	AC0883	Tissu à délaminer Release ply B	
Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)			

Date: Mardi, 2009-10-06 14:53:24
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 22383

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0017/-0018

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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48.0	AC0884	Wrighton 5200 Bleu P3
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Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)

49.0	AC0885	Feutre de drainage N° Airweave N 10
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Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

50.0	AC0882	Sac à vide N° Stretchlon 700
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Commentair Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)

51.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
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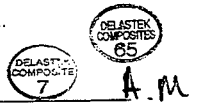
Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)

52.0	BAGGING	Faire le bagging sur la pièce
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Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le montage cuisson selon IF135-0001 et IG 0012.

Quantité: 1 Date: 13 mar 09 Sceau: 

53.0	CUISSON	Cuisson de pièce
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Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièces selon IF135-0001, IG 0012 , et PTN #20 N° de Cuisson: 6/46

Quantité: 1 Date: 13 mar 09 Sceau: 


54.0	DÉMOULAGE	Démoulage de la pièce
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Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Retirer le montage cuisson et faire des retouches sur la pièce afin d'enlever les surplus de résine et les résidus de tissu à délaminer

Retirer la pièce du moule

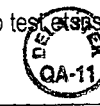
Quantité: 1 Date: 18 mar 09 Sceau: 

55.0	INSPECTION	Inspection générale
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection par le département de la qualité "Tap test et inspection dimensionnel"

Quantité: 1 Date: 24-11-09 Sceau: 

Date: Mardi, 2009-10-06 14:53:24

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 22383

Numéro Article: DKC135-0017/-0018

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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56.0	TRIMAGE	Trimage / Rivetage
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Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le trimage de finition de la pièce selon IF135-0003

Quantité: 1 Date: 20-11-09 Sceau: R.C.



57.0	AAC1021	Dupont Primer N° 7704S
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Commentair Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s)

Dupont Primer N° 7704S N° de Lot: 2-25136-3

58.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
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Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-24359-3

59.0	PRIMER	Application primer
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Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire l'application du primer selon IG 0008.

Quantité: 1 Date: 24/11/09 Sceau: 10 N° Fiche mélange: N/A



60.0	SABLAGE	Sablage
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Commentair Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs

Faire le sablage du primer selon IF135-0003

Quantité: 1 Date: 25-11-09 Sceau: 34



61.0	PRIMER	Application primer
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Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire l'application du primer selon IG 0008.

Quantité: 1 Date: 25/11/09 Sceau: 10 N° Fiche mélange: N/A



62.0	IDENTIFICATION	Identification à encre indélébile
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'identification des pièces sur l'aluminium peinturé dans le dégagement des mécanisme de porte selon IG 0055.

Date: Mardi, 2009-10-06 14:53:24
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 22383

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0017/-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

N° de pièce Grosse porte: D3140-05

N° de pièce Petite porte: D3140-07

N° de Job (sur les 2 pièces):

#22383

Date de fabrication (sur les 2 pièces):

NOV 25 2009

Sceau d'inspection.

Quantité:

NOV 26 2009

Date:

Sceau:



63.0

INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire l'inspection finale des pièces par le département de la qualité selon le dessin D3140.

Quantité: 1

Date: 27-11-09

Sceau:



64.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Emballer et entreposer selon IG 0057

Quantité: 1

Date: 1 dec 09

Sceau:



